

5184713



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6101-007
Job Sheet 194498



Part No: D6101-007

Job Qty: 40 pcs

Part Name: Saddle Billet



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/3/19

Job Tracking No:

Due Date: 5/31/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	40 pcs	5/31/19	5/31/19	0.00	0.00	Purchasing - 1	
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	40 pcs	5/31/19	5/31/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	

Plex 5/3/19 8:55 AM Dart.Guerin.Kimberley

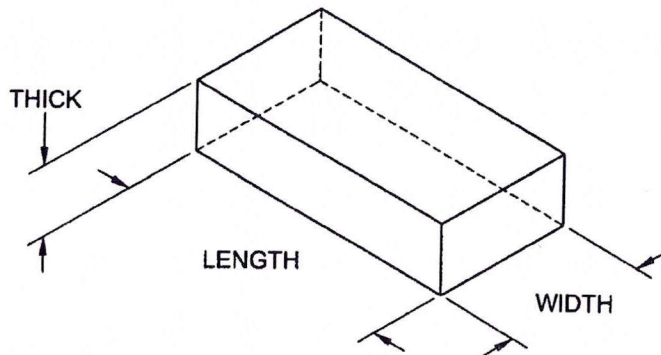
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	40 pcs	5/31/19	0.00	0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61 VM	
					QC 6 - 40	
130 Packaging 3-1 - Stock - B4B	40 pcs	5/31/19	0.00	0.00	Packaging 3 - 1 - B4B	0.7
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	40 pcs	5/31/19	0.00	0.00	QC 21 - SA - 21	DAG
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-18
Part Op 100 - Issue P/O: _____ b) 7.750" x 8.250" x 2.50" thick d) Grain direction along 7.750" length Descriptions: 110 - (Receive & Inspect for Damage & Mat'l Certs), Ensure material certification is attached 120 - (QC6- All purchased or subcontracted products), Ensure Material certification comply to Dwg D6101 130 - (Identify as per dwg & Stock Location: _____), LOCATION: MAT041 140 - (QC21- Final Inspection - Work Order Release)						

MAY 29 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-007P	7075-T7351 8.25X7.75X2.5	40 pcs (1 ea)	100-Purchasing	
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6101-007P	40	0	0
Part Specifications				
Specifications could not be found.				

Plex 5/3/19 8:55 AM Dart.Guerin.Kimberley

SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

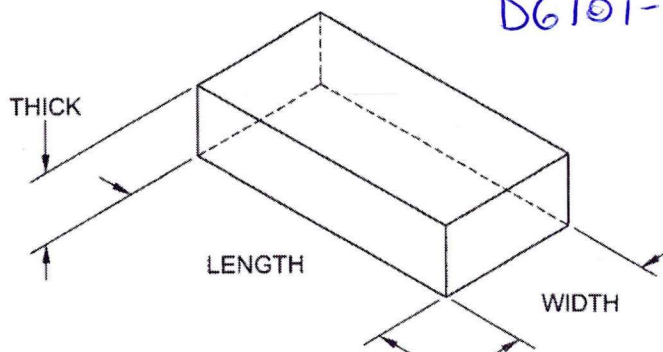
B

RELEASED
09/07/15/WP

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SPECIFICATION CONTROL DRAWING

Line 4
D6101-007



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

△ ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209 *Um*

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

△ B

RELEASED
09/07/15/WB

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB043369**



Supplier: MEC002-VU
Metaux Castle
P.O. Box 4090 Str A
Toronto
ON
M5W OE9 Canada

PO No: POHB043369
PO Date: 5/3/19
Due Date: 5/24/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

E-MAILED
2019-05-03

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	194485	D6101-001P	72746	7075-T7351 2X6X6.25 : Various STC's AS PER DWG D6101 REV. B SIZE: 6.00" X 6.250" X 2.00" THICK GRAIN DIRECTION ALONG 6.00" LENGHT MATERIAL: 7075- T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	5/24/19	20 pcs	0 pcs	20 pcs	\$29.57/pcs	\$591.40
2	194489	D6101-003P	72742	7075-T7351 2X6.25X7.875 : Various STC's AS PER DWG D6101 REV. B SIZE: 7.875" X 6.250" X 2.00" THICK GRAIN DIRECTION ALONG 7.875" LENGHT MATERIAL: 7075- T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	5/24/19	20 pcs	0 pcs	20 pcs	\$38.82/pcs	\$776.40



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB043369**



Items												
Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
3	194493	D6101-005P	72744	7075-T7351 8.25X5.0X2.5 : Various STC's AS PER DWG.D6101 REV.B SIZE: 5.00" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG 5.00" LENGHT MATERIAL: 7075- T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	5/24/19	20 pcs	0 pcs	20 pcs	\$40.54/pcs	\$810.80
4	194498	D6101-007P	72743	7075-T7351 8.25X7.75X2.5 : Various STC's AS PER DWG D6101 REV. B MATERIAL: 7075- T7351 (QQ-A- 250/12) SIZE: 7.750" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG: 7.750" LENGTH TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	5/24/19	40 pcs	0 pcs	40 pcs	\$61.72/pcs	\$2,468.80
5	194499	D6103-003P		Round Alum Billet : Various STC's AS PER DWG D6103 REV. B MATERIAL: 7075- T7351 AS PER QQ- A-225/9 SIZE: 3.500" X 12.500" LONG	Firmed	-	5/24/19	10 pcs	0 pcs	10 pcs	\$60.40/pcs	\$604.00
6	194502	D6104-011P		17-4 SS Roundbar 6.50"OD : Various STC's	Firmed	-	5/24/19	10 pcs	10 pcs	10 pcs	\$128.20/pcs	\$1,282.00
Grand Total:											\$6,533.40	

5/3/2019

PURCHASE ORDER



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB043369



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT

- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

- A049 SUPPLIER AWARENESS

Three handwritten signatures in black ink. The top signature is "CL", the middle one is "KH", and the bottom one is a large, stylized signature.

Plex 5/3/19 11:26 AM Dart.Guerin.Kimberley

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 2

Shipment No:3909156

Ship From: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped	F.O.B.	Freight Terms		Carrier		BOL No	
22-MAY-19	ORIGIN	Prepaid		LOCAL FLEET		3909156-7	

Shipment Details	Final Destination Branch - TOR
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Order No	Line No	Item No	Description	
5479658	4	752241.MO	2.5000.PL.7075.T7351.ALUMINUM.USI.48.5000.144.5000 CUT RECTANGLE TO 8.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 7.75")) X 7.75 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 7.75")) - ALUMINUM PLATE SAW SPECIFICATIONS: AMS-QQ-A-250/12	
Purchase Order No		Part Number	Ordered Qty	Invoice Qty
POHB043369		YOUR ITEM NUMBER: D6101-007	40.00 PCS	40.00 PCS

Details	ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS
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Delivery No. 122684220	Mill/Source KAISER ALUMINUM	Heat Number  30044584	Mech Id	PCS 40	Width (IN)	Length (IN)	Shipped Qty(LBS) 661.2674
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We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned

Date Printed: 22-MAY-2019 03:15:50 PM

SHIP TO:

A M CASTLE & CO
14001 ORANGE AVE
P.O. BOX 1402
PARAMOUNT, CA 90723

SOLD TO:

AM CASTLE & CO- SOLD TO
1420 KENSINGTON RD
SUITE 220
OAK BROOK, IL 60523

KAISER ALUMINUM

Trentwood Works

PO Box 15108, Spokane Valley WA 99215-510

15000 E Euclid, Spokane Valley WA 99216

Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number

4551915

CUSTOMER PO NUMBER: 484033-1	WORK PACKAGE:	CUSTOMER PART NUMBER: 752241	SHIP RUN/LOAD: 104542/18	GOV'T CONTRACT NUMBER:
KAISER ORDER NO: 1273335-1	SHIP DATE: 18-FEB-2019	ALLOY: 7075	CLAD: BARE	TEMPER: T7351
WEIGHT SHIPPED: 7184 LB (3258.64 KG)	QUANTITY: 4 PCS EST.	TRUCK B/L #: 2079167	GAUGE: 2.5000 IN (63.5000 MM)	DIAMETER/WIDTH: 48.500 IN (1231.9 MM)
				LENGTH: 144.500 IN (3670.3 MM)

MHU 2302280: LOT 300445B4: 2 pieces;

MHU 2302281: LOT 300445B4: 2 pieces;

Certified Specifications

AMS 4078/RevK

ASTM B 209/Rev14

BSS 7055/RevB

DPS 4.713/RevAK

GSS16100/RevG/Amd1

PS 21211/RevP

AMS-QQ-A-250/12/RevA

ASTM B 594/Rev13

CMMP 025/RevV

EAC MS1011/RevE

MMS 159/RevT

AMS-STD-2154/RevC

BAC 5439/RevJ

CSTI 006/RevE

GAMPS 9101/RevB/AmdSCN1

PPS 20.04/Rev7

Test Code: 4297

Lot: 300445B4 Cast 756

Drop 54

Test Results

Ingot 3

Melted in USA

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	70.6 : 70.8 (487 : 488)	59.3 : 59.6 (409 : 411)	12.4 : 12.5

(ASTM E1004)

(EN 2004-1)

Conductivity %IACS :	41.9 Min	42.0 Max
(MS/M) :	24.3 Min	24.4 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.07	0.17	1.5	0.03	2.4	0.19	5.7	0.03	0.01	0.01	TOT 0.04



MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6101-007
 DATE: May 28 2019

PO / BATCH NO.: P04B043369/
5184713

MATERIAL CERT REC'D: Yes
 QUANTITY RECEIVED: 40 pcs
 QUANTITY INSPECTED: 40 pcs
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 2.5"
 THICKNESS RECEIVED: 2.5"
 SHEET SIZE ORDERED: —
 SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	ASTM B209
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	HT: 300445 BY
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>✓m</u> 9-89 DATE: <u>MAY 28 2019</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in